

Work Order ID 69040

Page 1

Wednesday, April 27, 2011 11:23:45 AM

Item ID: D3550-1

Accept



Setup Start



Revision ID:

Item Name: Strut

Stop



Start Date: 4/27/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:



Date: 11/04/27 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3550	Rev B								
100		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	1-Form per Dwg D3550 using DT 8012								
110		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-form other end of strut at 1.8" using DT 8984□2-Deburr if necessary.								
120	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
QC									
Quality Control									

S. J. Clark

(12X)

⇒ M-F 11/04/28

(12X)

⇒ M-F 11/04/28

(x17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69040

Page 2

Wednesday, April 27, 2011 11:23:45 AM

Item ID: D3550-1

Accept



Setup Start



Revision ID:

Item Name: Strut

Stop



Start Date: 4/27/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Powdercoat

Powder Coating

W116964

Operation
Description

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

1:40

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:10

12x ✓ ml 11/05/10

150



Packaging

Packaging

Identify as per dwg & Stock Location: Z71

0.00

Memo

0.00

12 ✓ 11-5-10.

11/5/11 ✓ 12 ✓

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69040

Page 3

Wednesday, April 27, 2011 11:23:45 AM

Item ID: D3550-1

Accept



Setup Start



Revision ID:

Item Name: Strut

Stop



Start Date: 4/27/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/5/11

MF
11-05-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, April 27, 2011 11:23:50 AM

Work Order ID: 69040



Parent Item: D3550-1



Parent Item Name: Strut

Start Date: 4/27/2011

Required Date: 5/3/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A 07.02.05 New iwssue EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.049		Purchased		No		110	f	209.1605	1.7	21.47368			

304 RD Tube .500 x .049W



Location	Loc Qty	Loc Code
MAT017	209.16053	
111814	2.23	
115010 ✓	206.93053	

M-L 11/04/28

21-47368

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

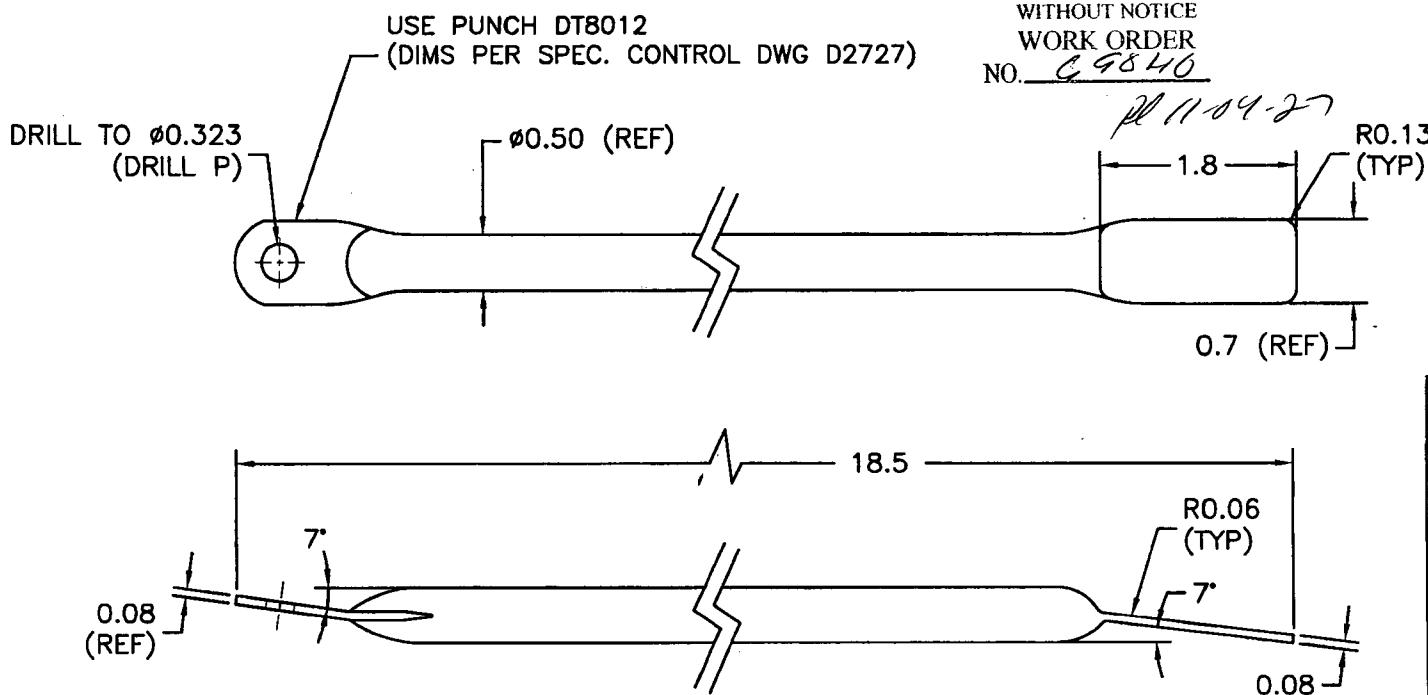
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. C 9840
P/N 11-04-27



D3550-1 STRUT

NOTES:

- 1) MATERIAL: 304/316 SS SEAMLESS ROUND TUBE 0.500 OD X 0.049 WALL
(REF DART SPEC M304TR0.500W.049)
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3550-1 USING FINE POINT PERMANENT INK MARKER

DESIGN <i>ce</i>	DRAWN BY <i>ce</i>	DART AEROSPACE LTD		
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3550	REV. B	SHEET 1 OF 1
DATE 07.02.13	TITLE STRUT	SCALE NTS		
A	06.10.24	NEW ISSUE		
B	07.02.13	18.5 WAS 20.13; 1.8 WAS 1.5		

07-02-27 - PH

RELEASED

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries